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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: PR2		N/C
N/C	INITIAL RELEASE	06/01/09	P. BRAVO
A	INCORPORATED ECN 03686	11/12/12	P. BRAVO
B	INCORPORATED ECN 06607	02/19/21	J. GARDINER

NOTES:

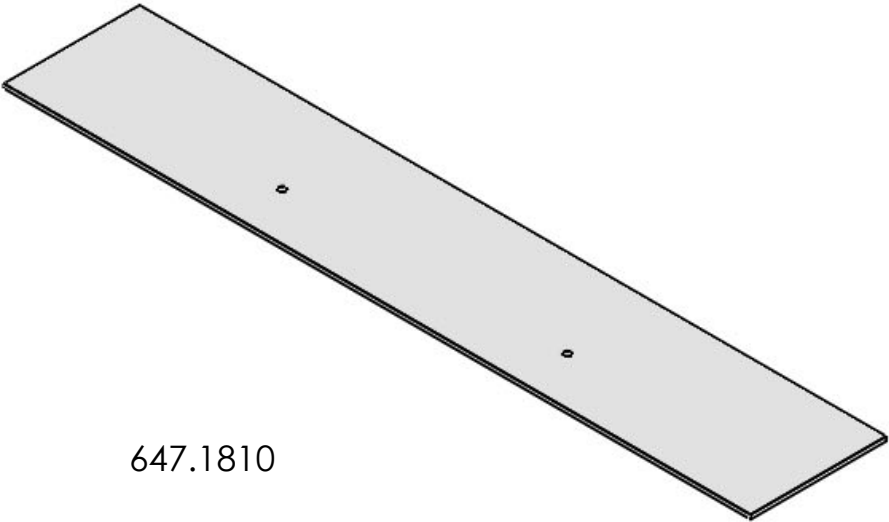
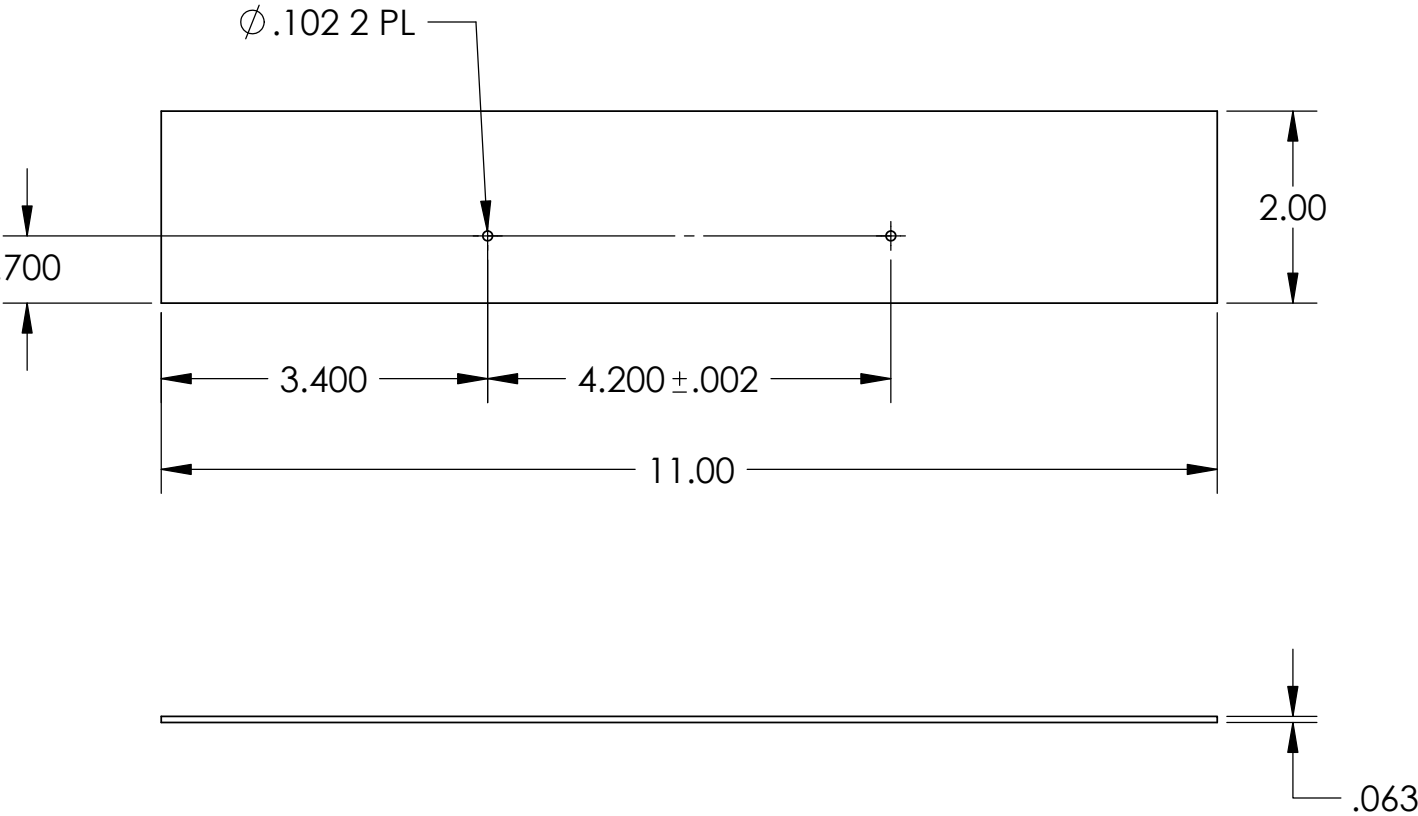
- 1

PRIMARY MATERIAL: 2024-T3 ALUMINUM PER AMS-QQ-A-250/4
ALTERNATE MATERIAL: 6061-T6/T62 ALUMINUM PER AMS-QQ-A-250/11
- 2

FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3

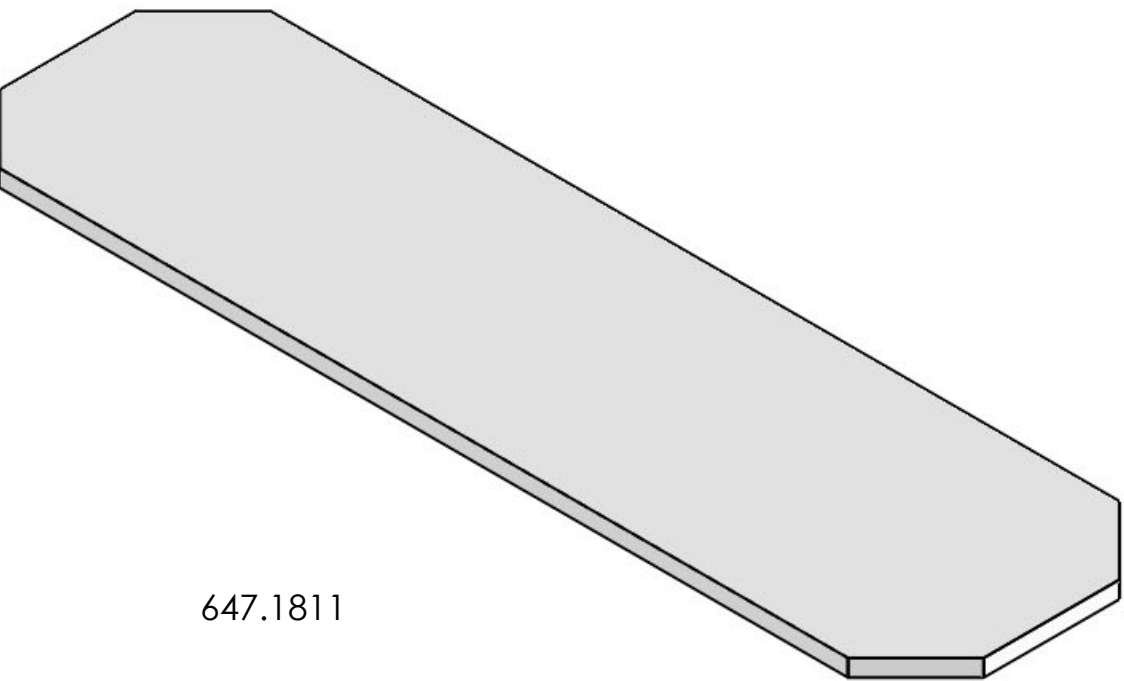
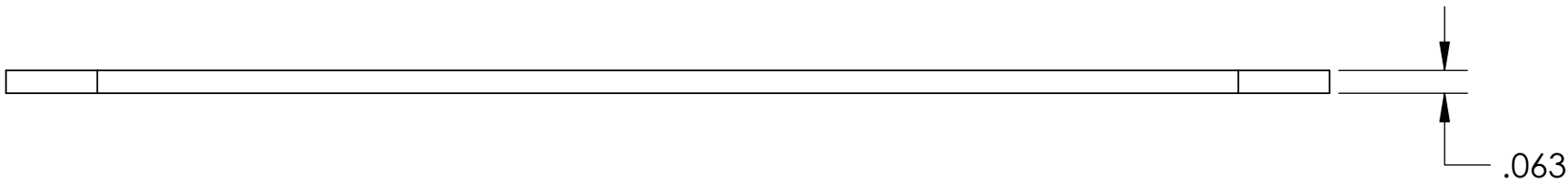
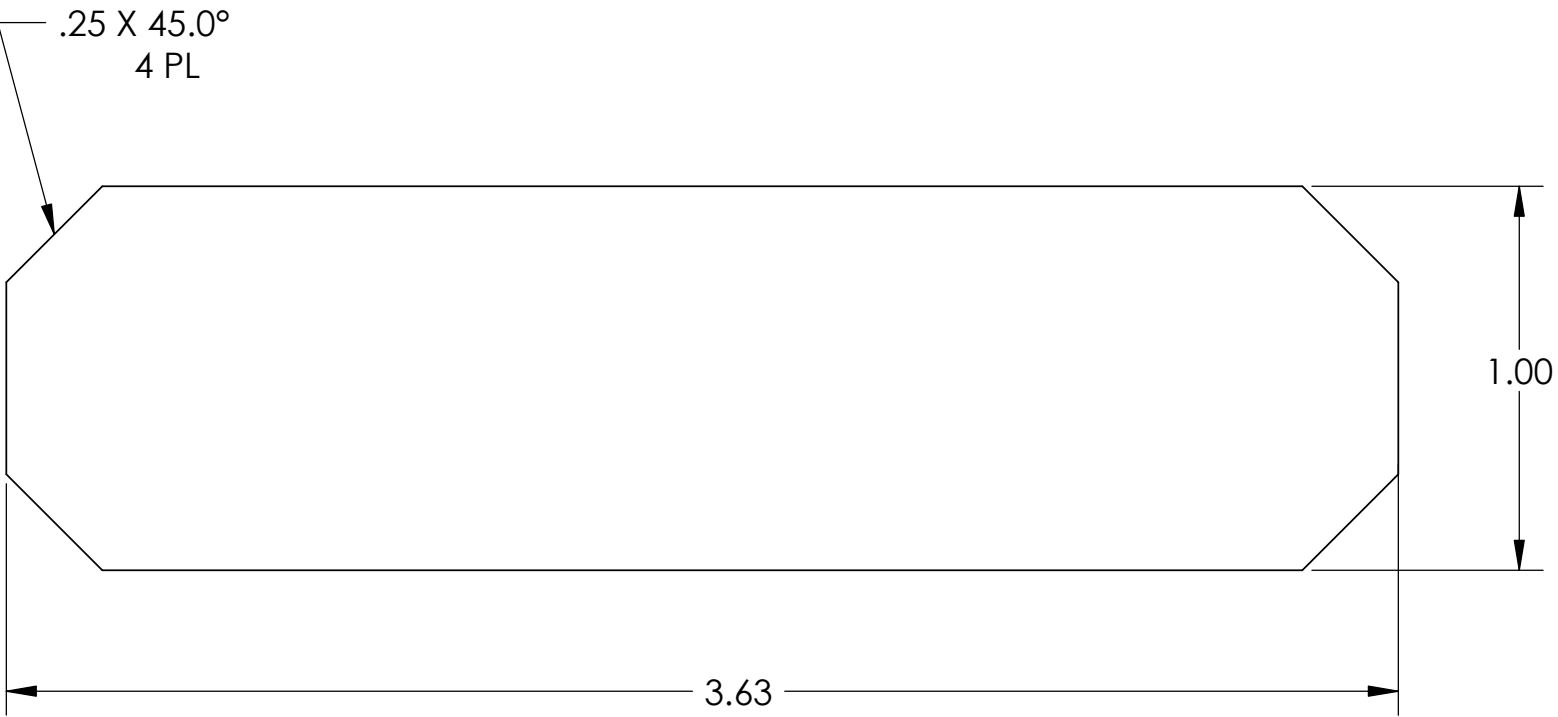
DEBURR AND BREAK ALL SHARP EDGES
- 4

IDENTIFY IAW MPP-120



				647.1819	BRACKET	<div>1</div>	<div>2</div>
				647.1818	NOSE DOOR SPACER	<div>1</div>	<div>2</div>
				647.1817	SUPPORT, RH	<div>1</div>	<div>2</div>
				647.1816	SUPPORT, LH	<div>1</div>	<div>2</div>
				647.1815	GUSSET, RH	<div>1</div>	<div>2</div>
				647.1814	GUSSET, LH	<div>1</div>	<div>2</div>
				647.1813	ANGLE	<div>1</div>	<div>2</div>
				647.1812	SHIM	<div>1</div>	<div>2</div>
				647.1811	SPACER	<div>1</div>	<div>2</div>
				647.1810	NOSE DOOR DOUBLER	<div>1</div>	<div>2</div>
			FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY			PARTS LIST				
NEXT ASSY (S)			ORIGINAL DATE (MO-DA-YR) 06-01-09		<div><div><div>DART</div><div>AEROSPACE</div><div>APICAL INDUSTRIES, INC. dba DART AEROSPACE</div></div><div>3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300</div></div>		
647.1300			DRAWN BY J. GARDINER	CHECKER P. BRAVO			
			DRAWING APPROVAL P. BRAVO 06-01-09				
			CONTRACT No.				
			UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SHEETMETAL		
SIZE B		CAGE CODE 07MZ6		DWG. NO. 647.1800		REV. B	
SCALE NONE				SHEET 1 OF 8			

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ANGLES ± .5°

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SHEETMETAL			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.1800	REV. B
SCALE NONE		SHEET 2 OF 8	

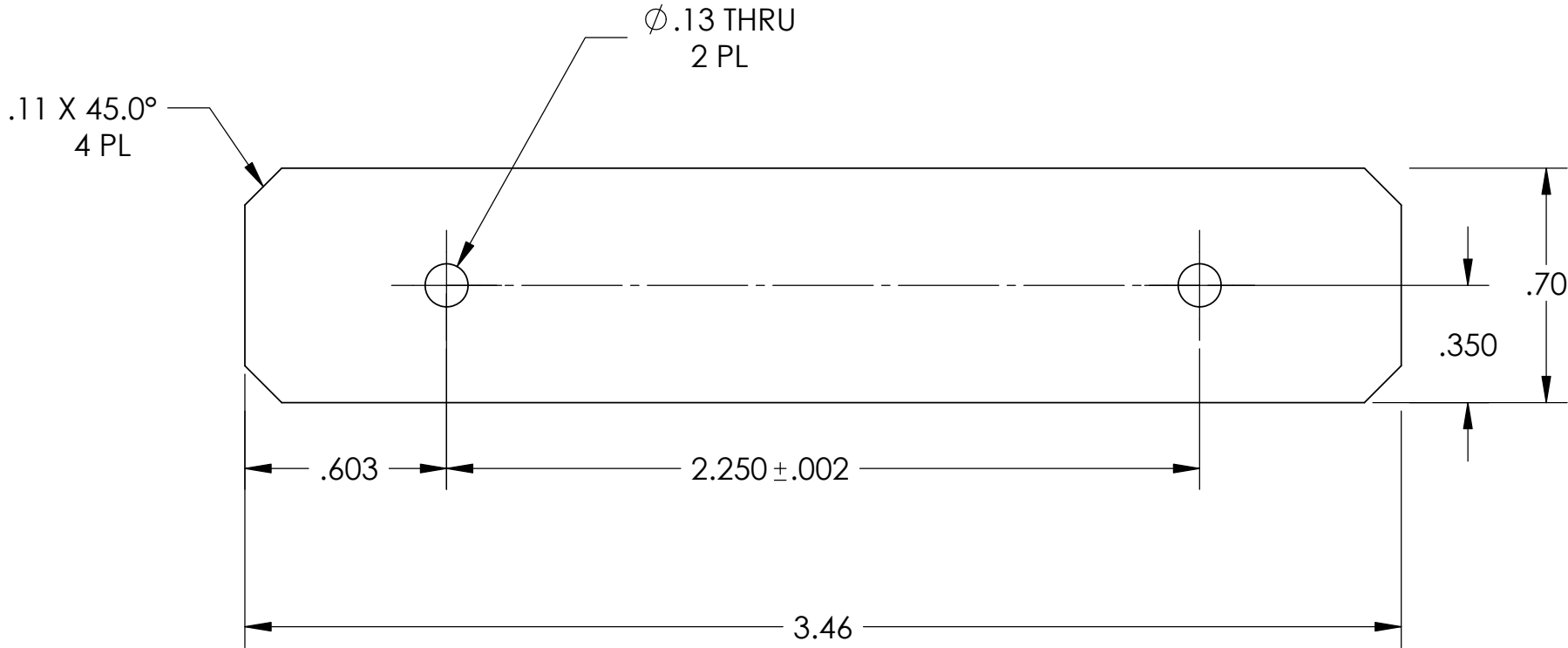
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A

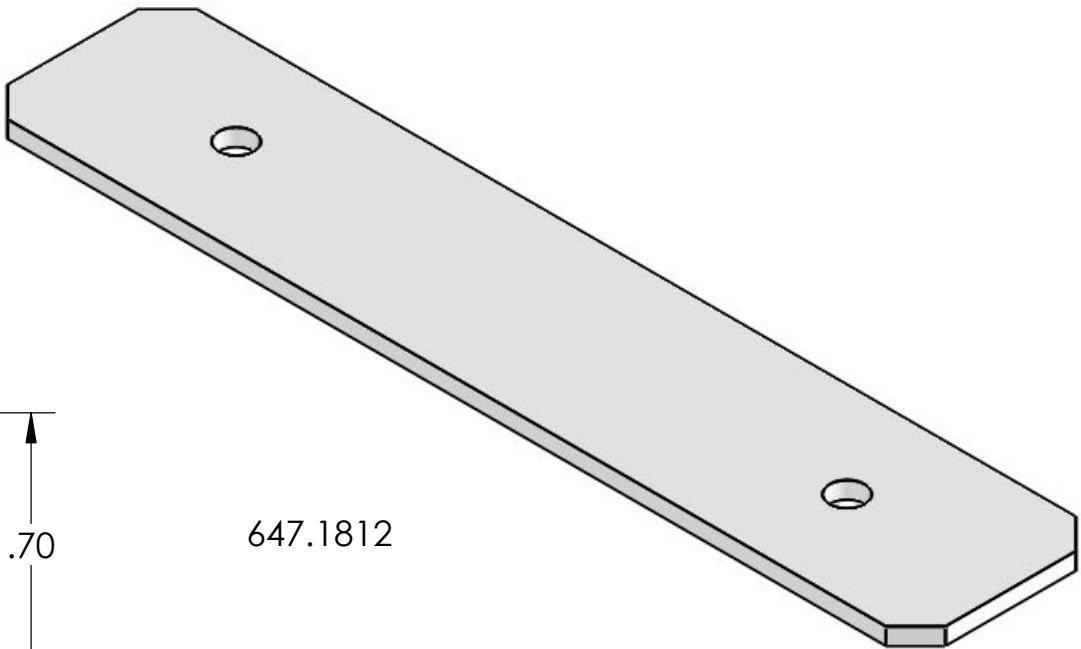
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C

D



647.1812



.063

ORIGINAL DATE (MO-DA-YR)		06-01-09
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ANGLES ± .5°

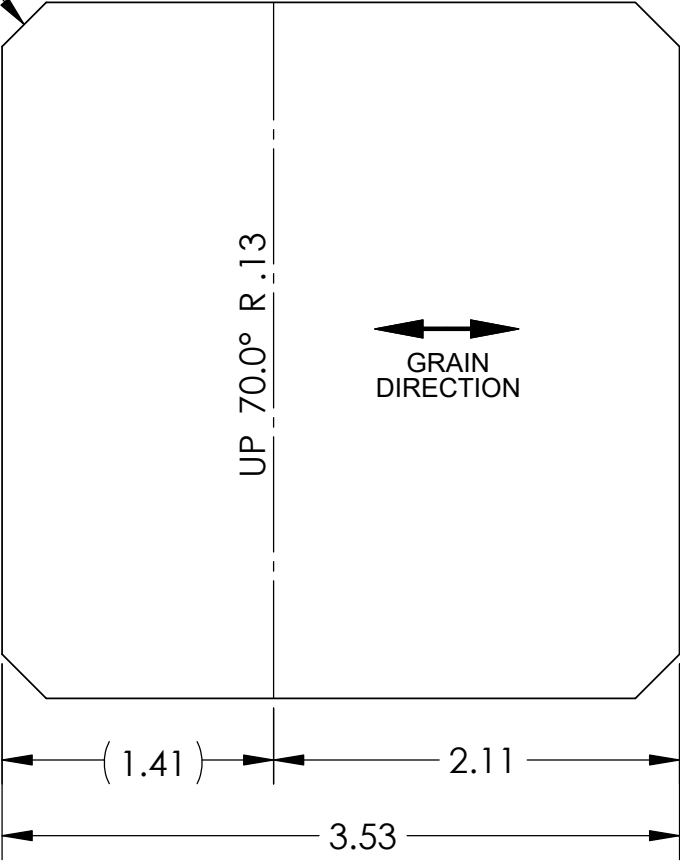
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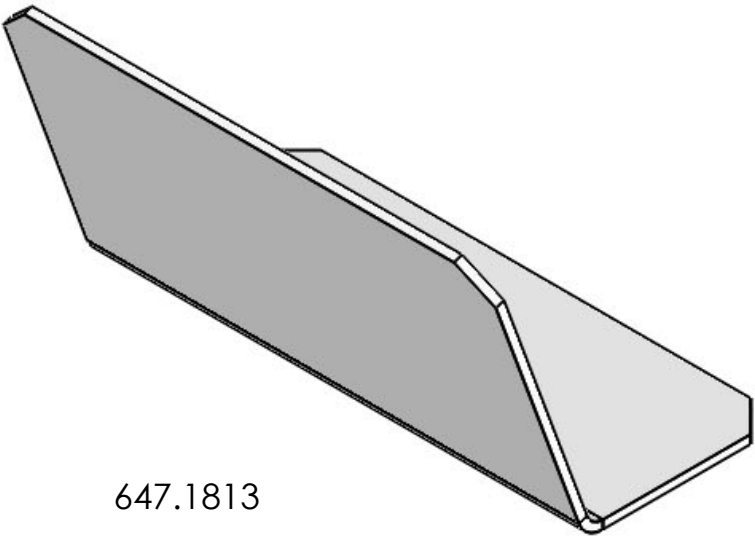
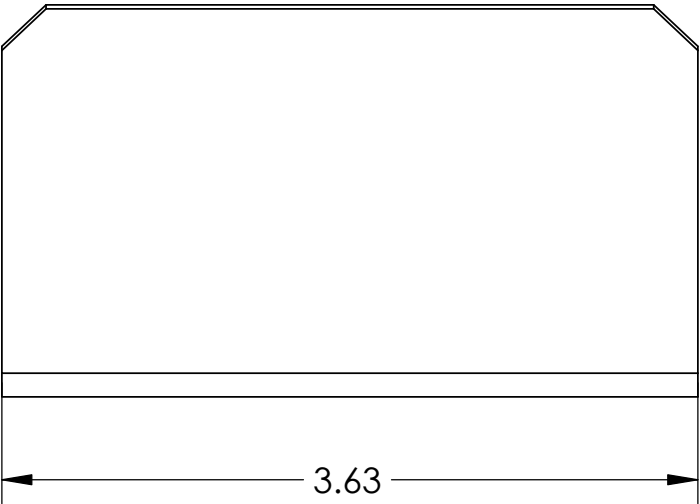
SHEETMETAL			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.1800	REV. B
SCALE NONE		SHEET 3 OF 8	

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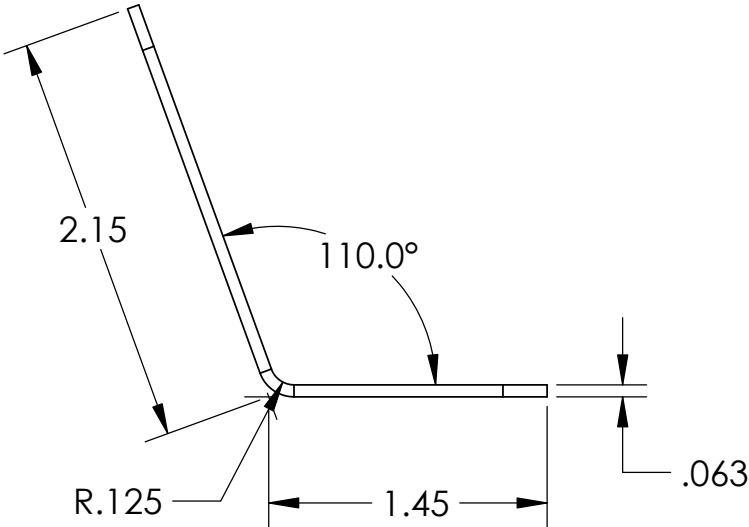
.23 X 45.0°
PL



FLAT PATTERN



647.1813



ORIGINAL DATE (MO-DA-YR)		06-01-09
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DRAWING APPROVAL P. BRAVO 06-01-09		
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ANGLES ± .5°

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SHEETMETAL

SIZE	CAGE CODE	DWG. NO.	REV.
B	07MZ6	647.1800	B
SCALE NONE			SHEET 4 OF 8

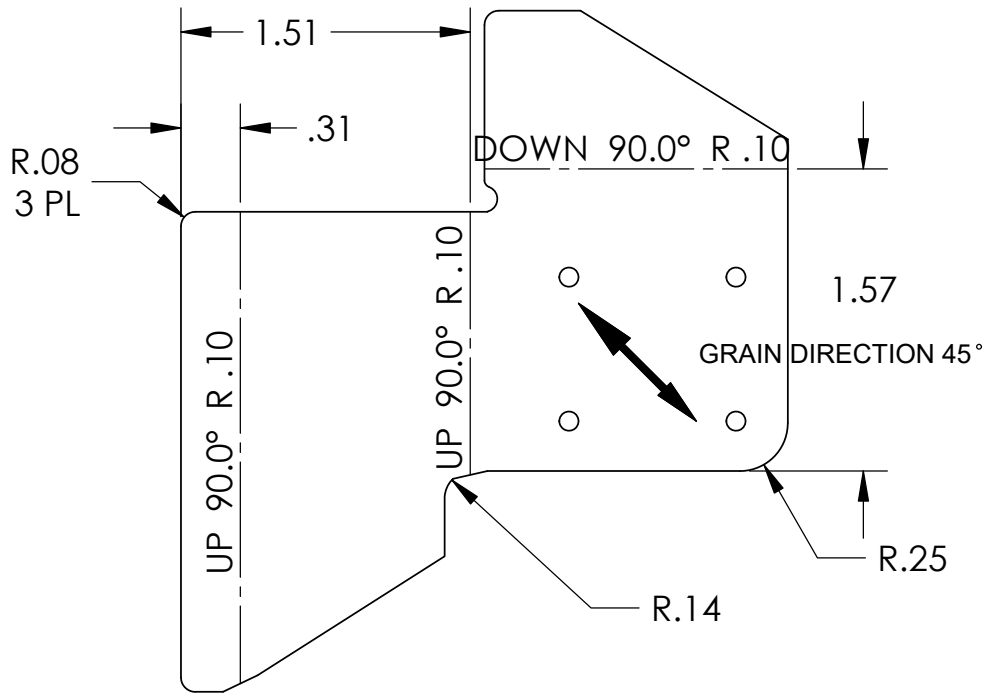
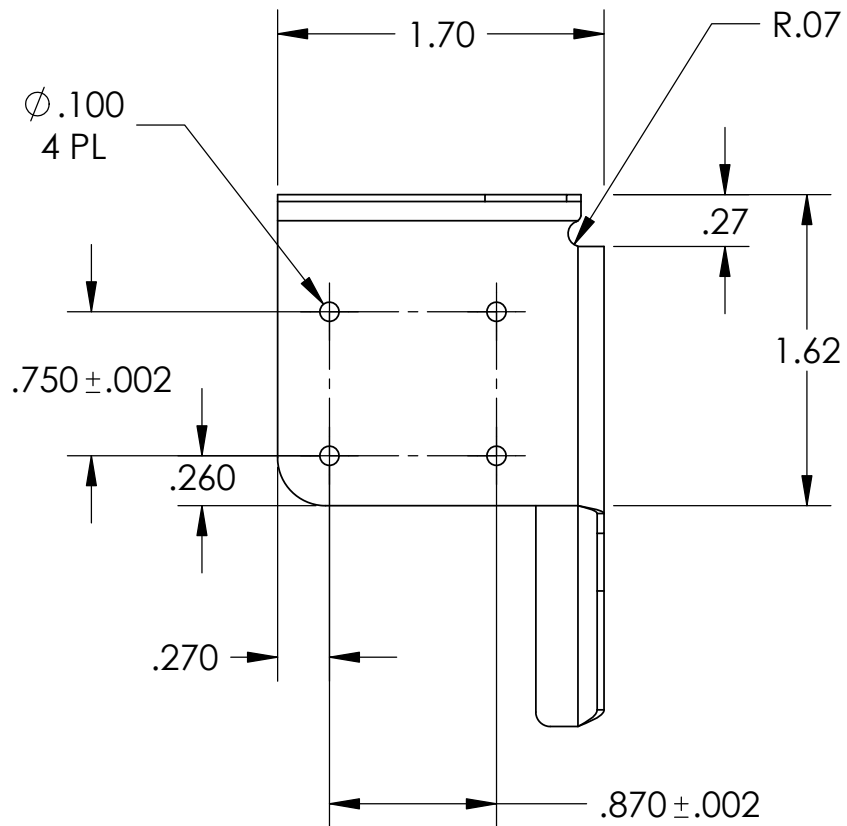
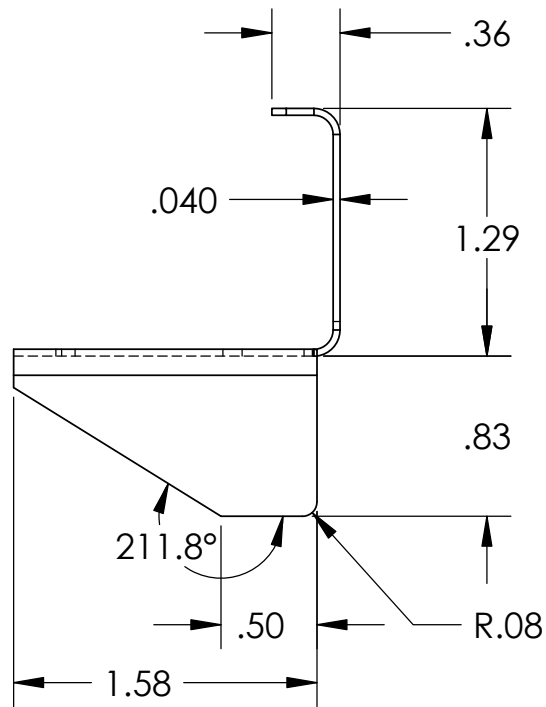
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A

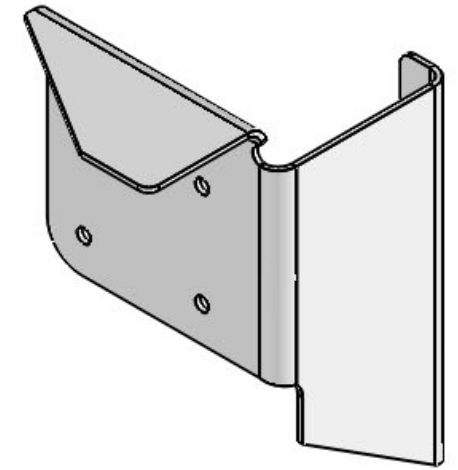
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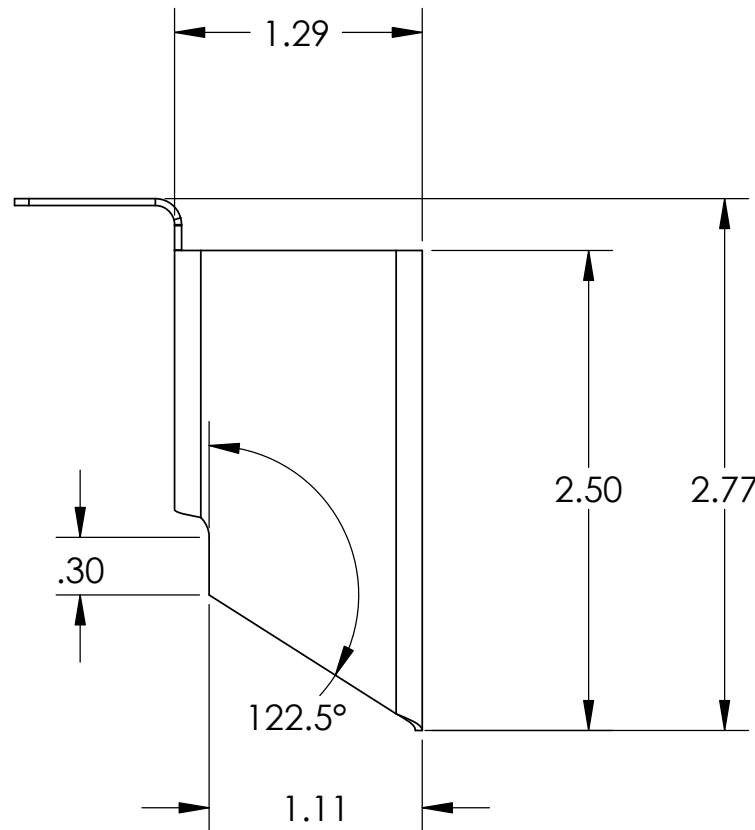
D




FLAT PATTERN



647.1814 SHOWN
647.1815 OPPOSITE



ORIGINAL DATE (MO-DA-YR) 06-01-09		 DART AEROSPACE APICAL INDUSTRIES, INC. dba DART AEROSPACE		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY J. GARDINER	CHECKER P. BRAVO				
DRAWING APPROVAL P. BRAVO 06-01-09		SHEETMETAL			
CONTRACT No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.1800	REV. B
		SCALE NONE		SHEET 5 OF 8	

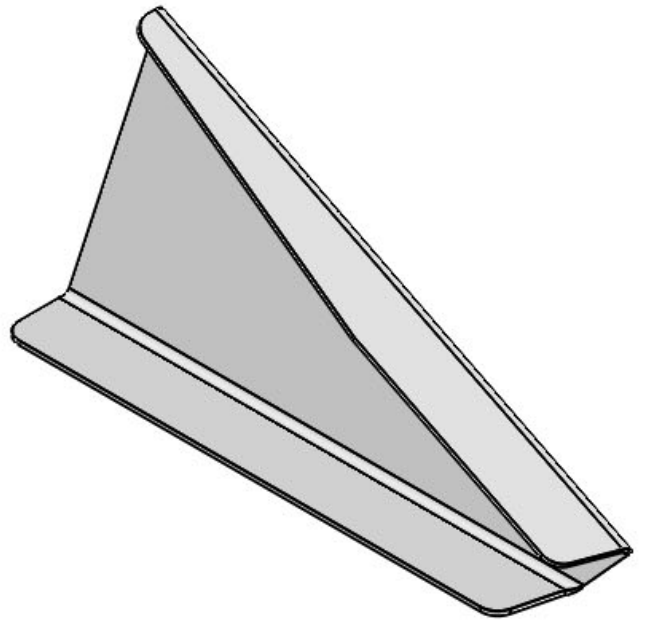
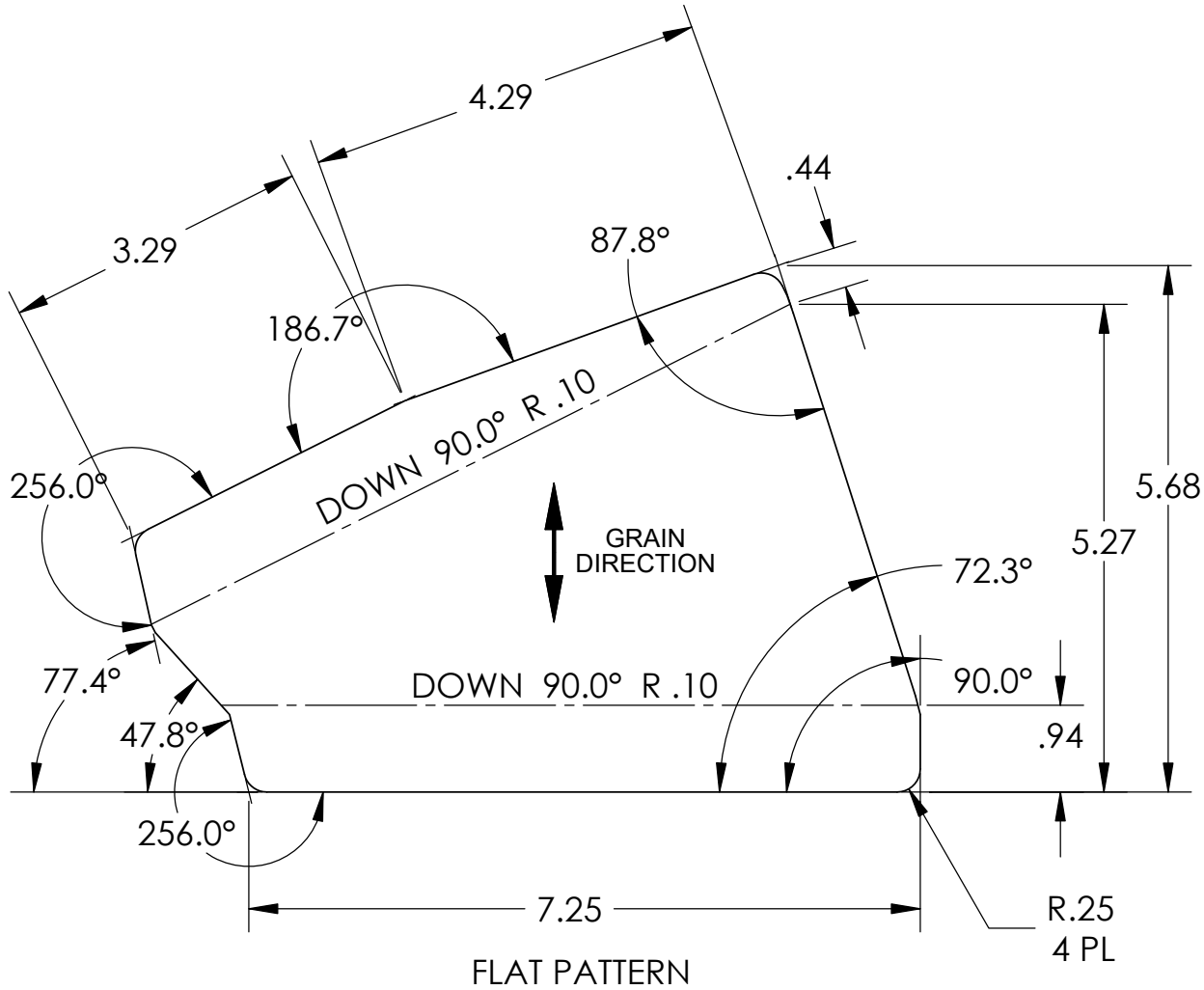
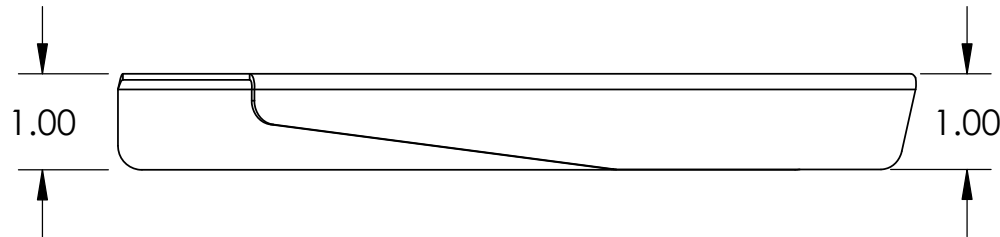
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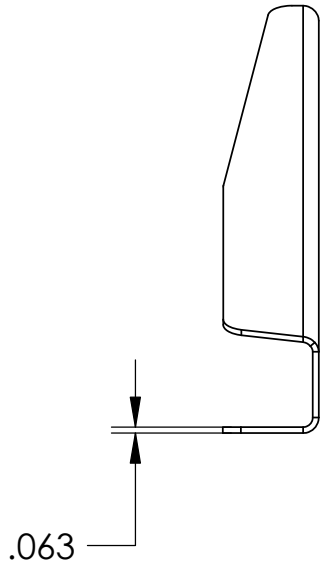
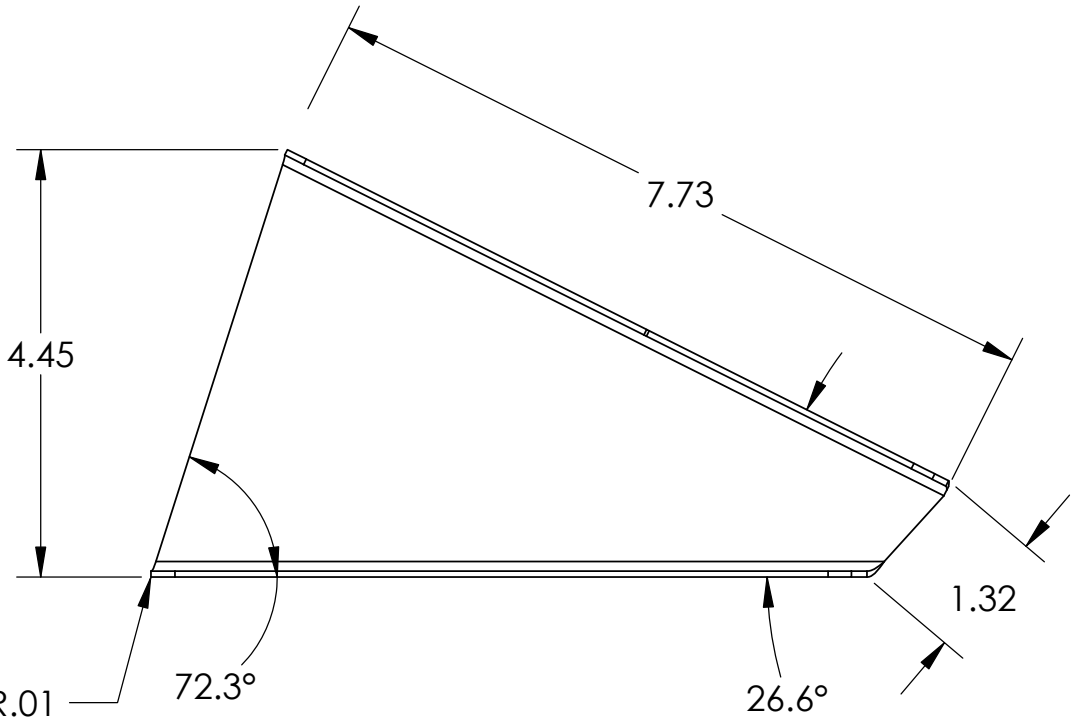
B

C

D



647.1816 SHOWN
647.1817 OPPOSITE

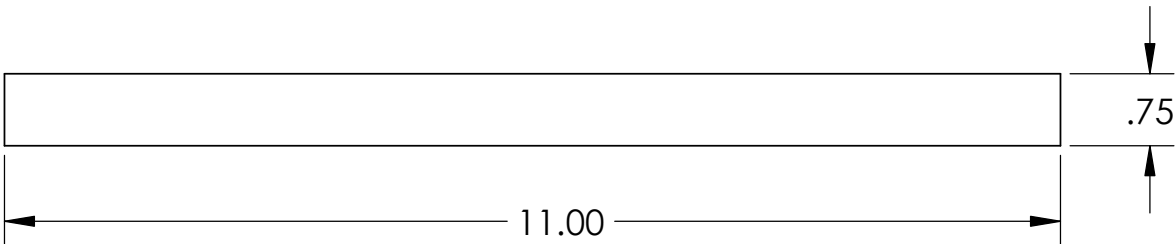


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DRAWING APPROVAL P. BRAVO 06-01-09		
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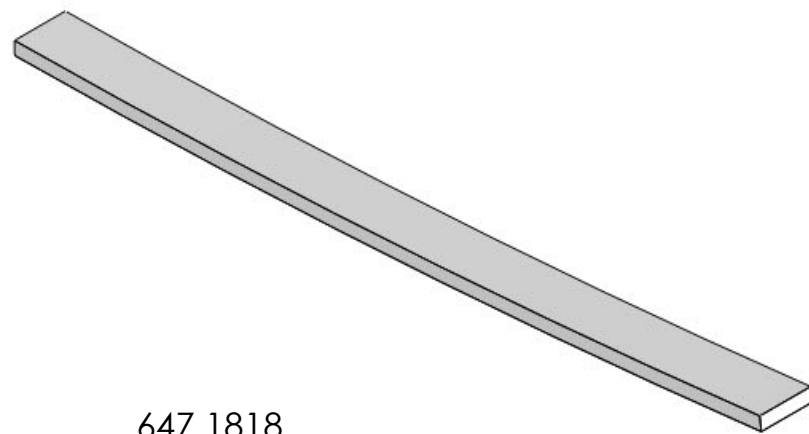
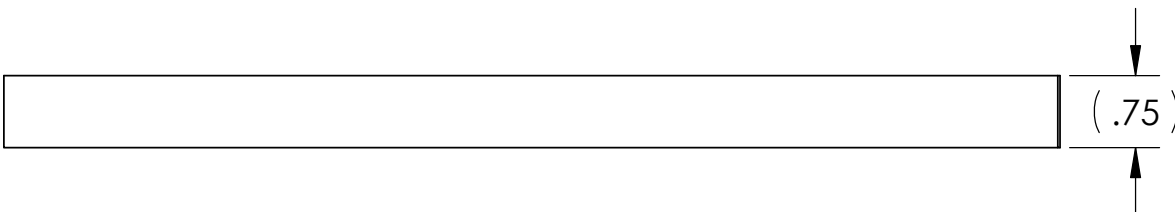
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ANGLES ± .5°

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APICAL INDUSTRIES, INC. dba DART AEROSPACE			
SHEETMETAL			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.1800	REV. B
SCALE NONE		SHEET 6 OF 8	

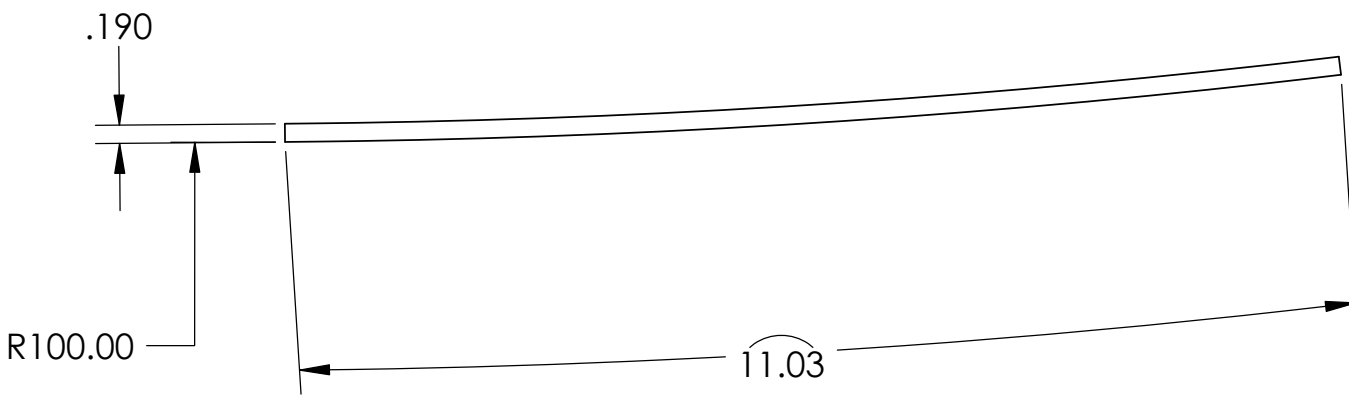
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FLAT PATTERN



647.1818



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DRAWING APPROVAL P. BRAVO 06-01-09	
CONTRACT No.	

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ANGLES ± .5°

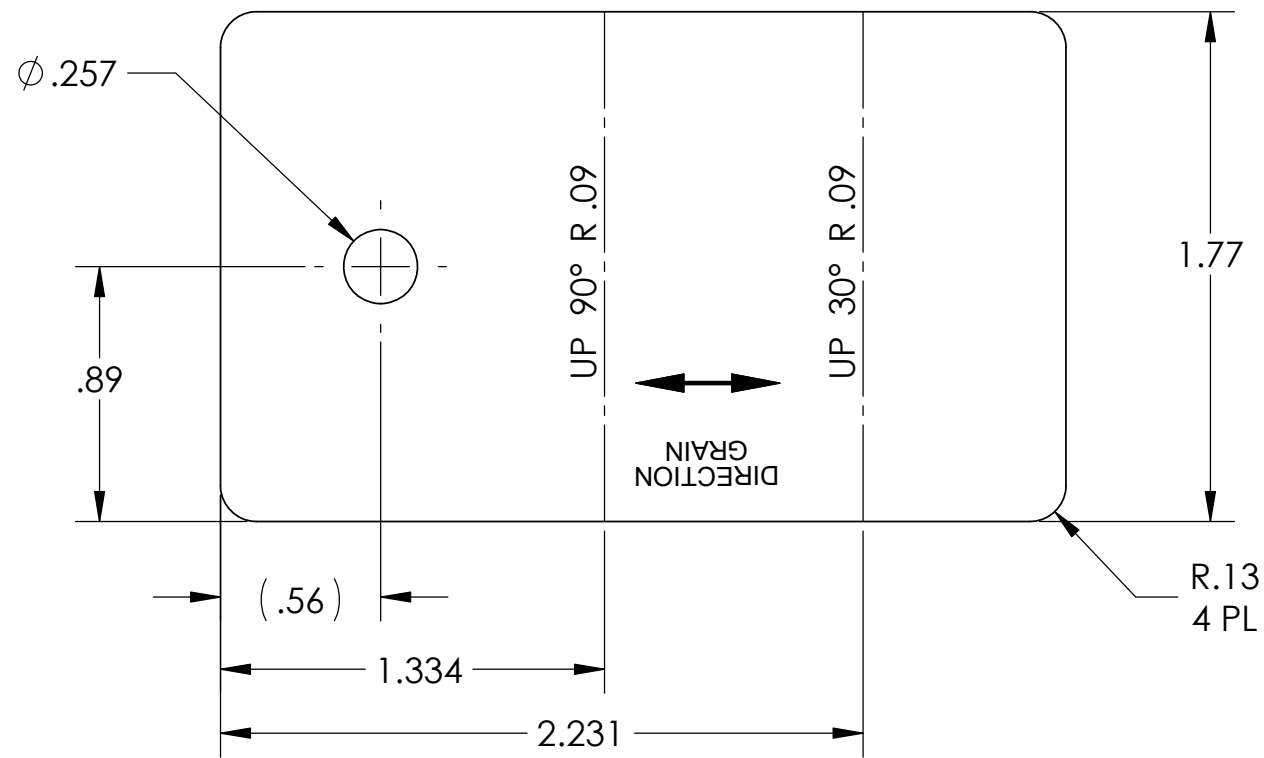
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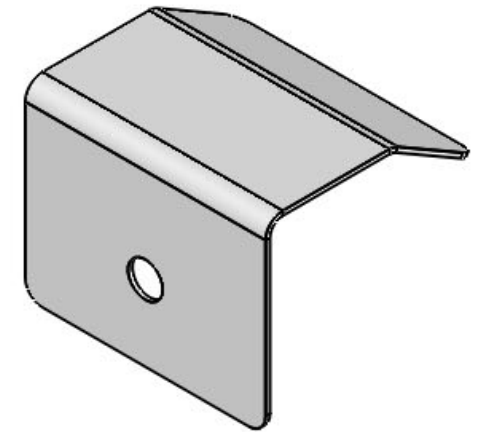
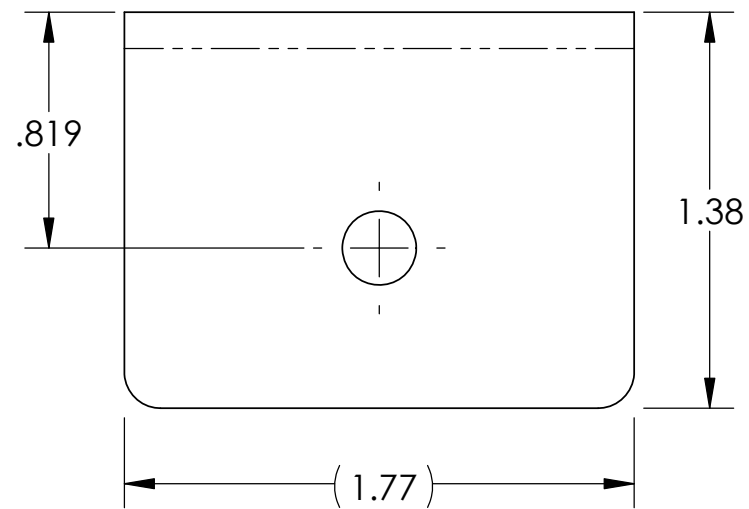
APICAL INDUSTRIES, INC.
dba DART AEROSPACE

SHEETMETAL			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.1800	REV. B
SCALE NONE		SHEET 7 OF 8	

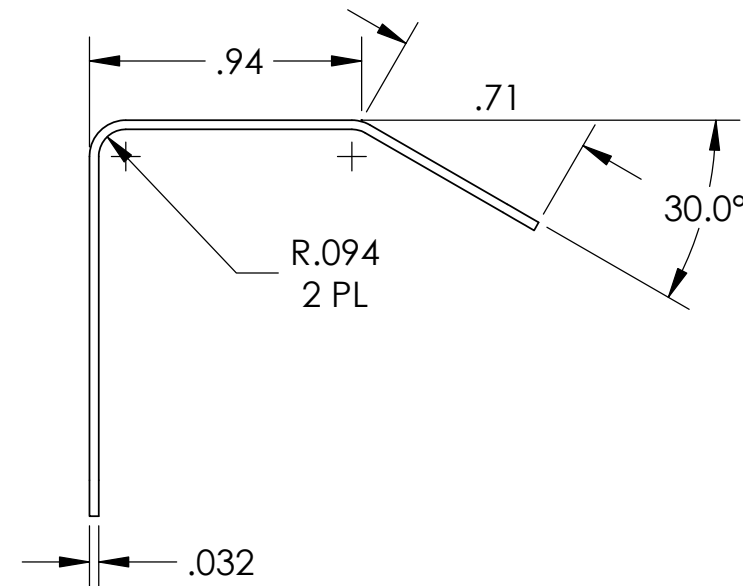
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647.1819



QTY		PARTS LIST				
NEXT ASSY (S) 647.1300	ORIGINAL DATE (MO-DA-YR)		06-01-09			
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	DRAWING APPROVAL P. BRAVO 06-01-09					
	CONTRACT No.		SHEETMETAL			
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		SIZE B	CAGE CODE 07MZ6	DWG. NO. 647.1800	REV. B	
		SCALE NONE		SHEET 8 OF 8		